

Work Order ID 65552

January 19, 2011 1:39:55 PM



Page 1

Item ID: D3065-5

Accept



Setup Start



Revision ID:

Item Name: Step Leg

Stop



Start Date: 1/20/11 Start Qty: 80.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-01-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D
if necessary

I Dwg Rev: B

I Prog Rev: B

I 2-Deburr

6061 -080

B11-1-24

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-1-24

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sulab24

Went
X80
2/20/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65552

January 19, 2011 1:39:55 PM



Page 2

Item ID: D3065-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Leg

Start Date: 1/20/11 Start Qty: 80.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 ⇒ 21 0.00	11/01/21			80	4		
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							80 11-01-21
150 Packaging Packaging	Identify as per dwg & Stock Location <u>SM4/FAB</u> Memo	0.00 0.00							1.1/24 s/Box

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65552

January 19, 2011 1:39:56 PM



Page 3

Item ID: D3065-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Leg

Start Date: 1/20/11 Start Qty: 80.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u/01/26 J

u u/01/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 19, 2011 1:39:54 PM

Page 1

Work Order ID: 65552



Parent Item: D3065-5



Parent Item Name: Step Leg

Start Date: 1/20/11

Required Date: 1/28/11

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP: ☐C☐02.11.01☐Incorporated D3066-1 IPP☐KJ/RF

IPP Rev:D Now on Water Jet 06-04-11 JLM

IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 		Purchased	No			100	sf	143.4000	0.825	69.47368			
6061-T6 .080 Sheet													

11-1-28

Location

Loc Qty

Loc Code

MAT

143.4

116268

143.4

116268

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 12552
Description: Step Leg		Part Number: D3065-5
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.458	*		T HB01	
15.750	+/-0.005	15.750	*		T	
2.250	+/-0.005	2.249	*		V HB02	
3.460	+/-0.005	3.462	*		V	
0.865	+/-0.005	.862	*		V	
6.020	+/-0.005	6.026	*		V	
1.205	+/-0.005	1.204	*		V	
3.484	+/-0.005	3.484	*		V	
0.871	+/-0.005	.869	*		V	
8.325	+/-0.010	8.329	*		V PRO W5 HB02	
0.551	+/-0.010	.554	*		V	
0.213	+0.005/-0.000	.215	*		V	
Ø0.128	+0.005/-0.000	.131	*		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-1-24	Date: 11/1/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

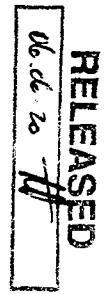
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

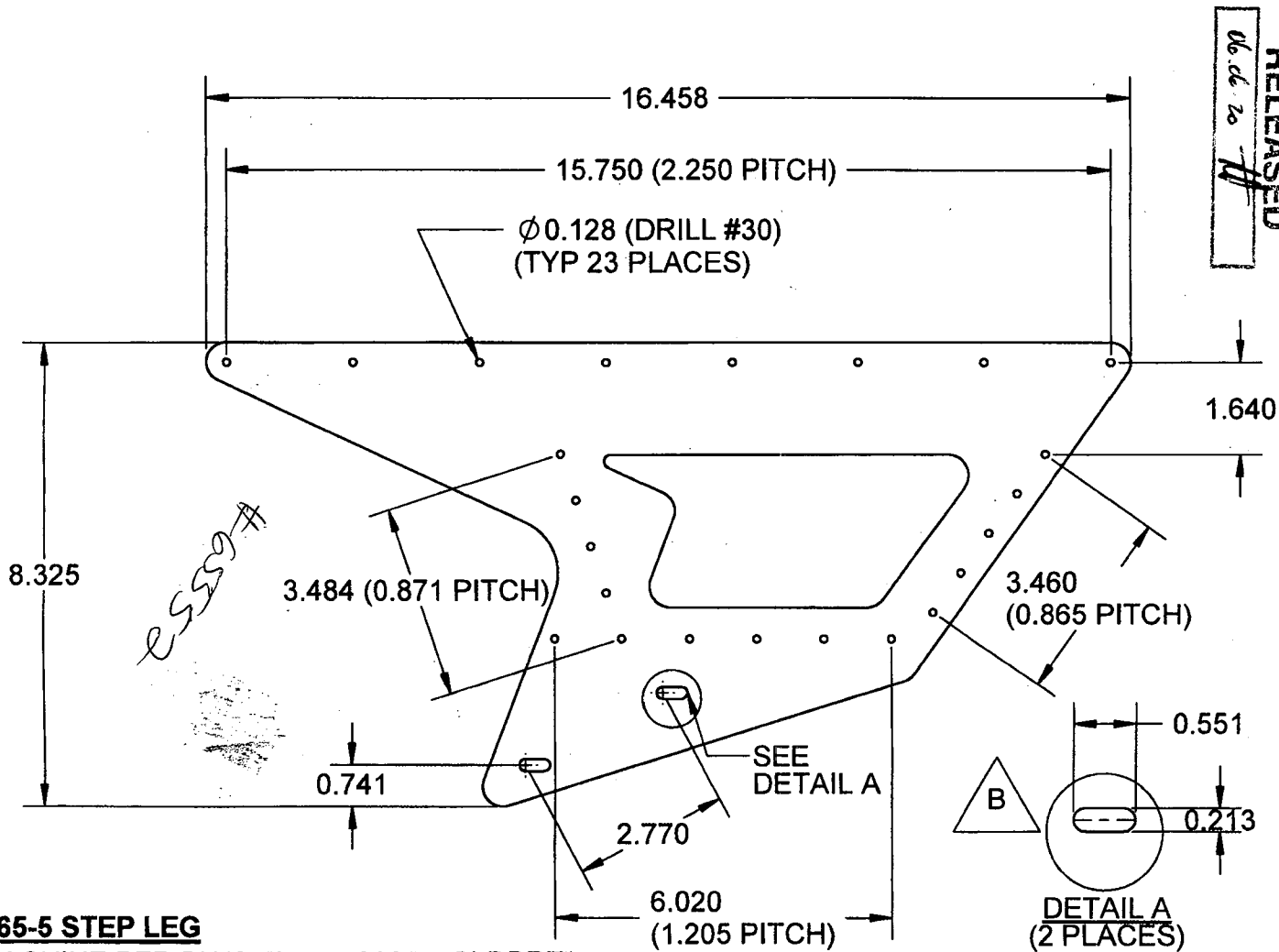
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>CP</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	APPROVED	<i>[Signature]</i>	
DATE	06.05.23			
		DRAWING NO.	D3065	REV. B
				SHEET 4 OF 5
		TITLE	STEP LEG ASSEMBLY	
		SCALE	1:3	



1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries